

W00#2014-50

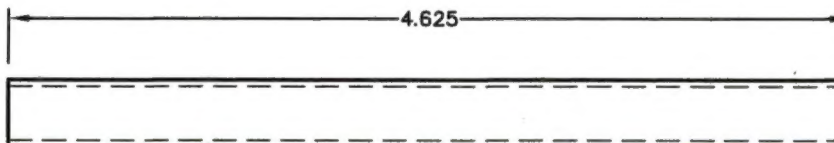
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*

# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

Ø0.375  
STOCK



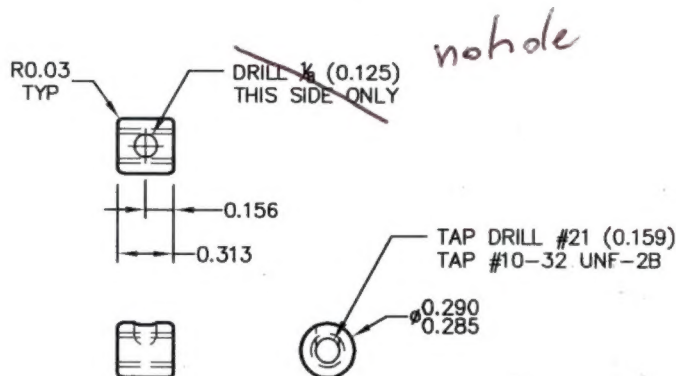
① TUBE

	95220-01	01	TUBE	304 STAINLESS STEEL	ASTM A269	ø0.375 X 0.035 TUBE	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS						
				APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (408) 850-8027 fax: (408) 850-8338 www.aerodesign.ca	
				DRAWN: JEFF CLARKE	18 OCT 2012		
				CHECKED: E. BURGAIN			
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		<b>BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - TUBE</b>	
SHEET 1 OF 1		A4	95220	0			

W0#2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



01 STOP

#### NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

	95236-01	01	STOP	304 STAINLESS STEEL	ASTM A479	Ø0.313 ROD	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY	LIST OF MATERIALS						
				APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-6027 fax: (403) 250-6333 www.aerodesign.ca	
				DRAWN: JEFF CLARKE	18 OCT 2012		
				CHECKED: E. BURGOIN		<b>BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - STOP</b>	
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			
				SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
				SHEET 1 OF 1	<b>A4</b>	<b>95236</b>	<b>0</b>

5/16" SS. rod

B# 13004

- Face 1380 rpm
- Turn 1380 rpm
- champher 1380 rpm (file)
- center drill 425 rpm
- drill 7/16" deep 425 rpm
- Tap 130 rpm
- deburr hole
- partial part 425 rpm
- champher 425 rpm
- part off 425 rpm

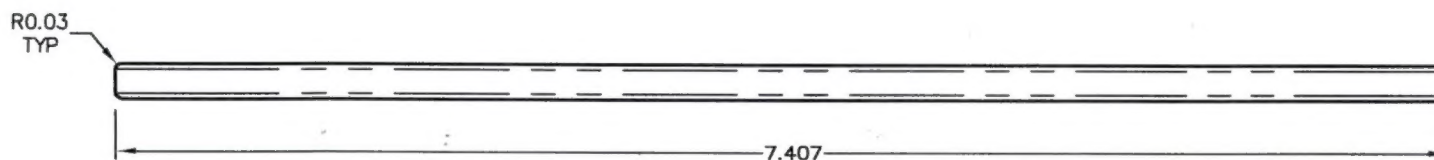
W0#2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*

# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



01 THREADED ROD

	95232-01	01	THREADED ROD	304 STAINLESS STEEL	ASTM F593	#10-32 THREADED ROD
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
			APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca	
			DRAWN: JEFF CLARKE	18 OCT 2012		
			CHECKED: E. BURGON			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1		BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - THREADED ROD	
					SCALE 1 : 1	DWG. SIZE
			SHEET 1 OF 1	A4	95232	0

- use  $\frac{3}{16}$ " collet with hollow stop to face to length.
- file corner after face step. 1380 RPM
- lock lathe bed, use compound only.



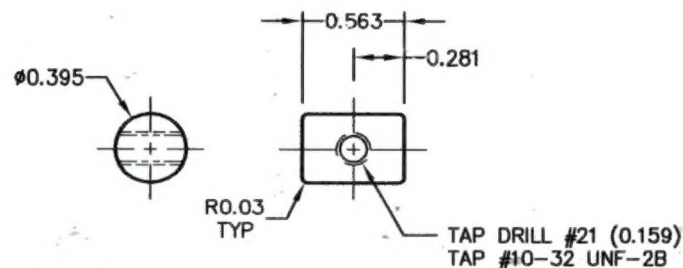
2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*

# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



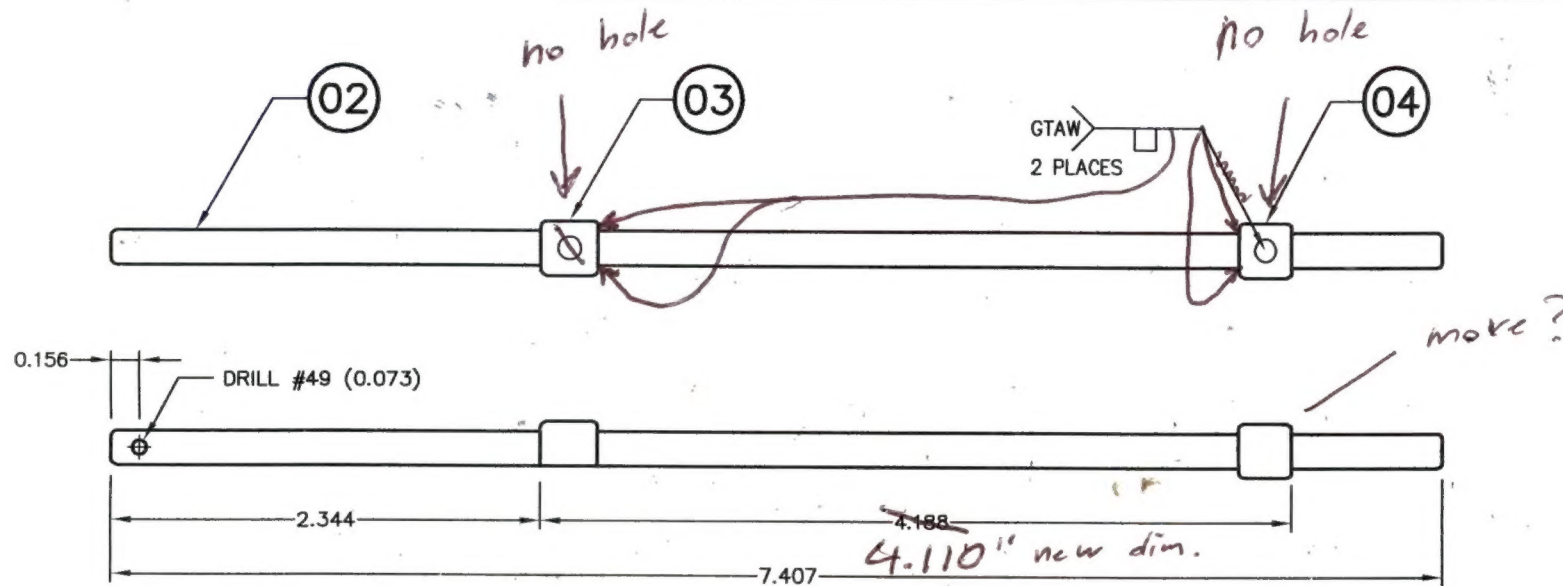
01 BARREL NUT

	95230-01	01	BARREL NUT	NYLON 101 PA66	COMMERCIAL	$\varnothing 0.5$ ROD
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
				APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca
				DRAWN: JEFF CLARKE	18 OCT 2012	
				CHECKED: E. BURGAIN		
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX $\pm 0.010$ $\pm 1/2^\circ$ X.XX $\pm 0.03$ X.X $\pm 0.1$		<b>BELL 206B, 206L SERIES, 407  CYCLIC FRICTION REPLACEMENT  PARTS - BARREL NUT</b>
				SCALE 1 : 1	DWG. SIZE	REV.
				SHEET 1 OF 1	A4	95230 0

WO 2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



# 01 THREADED ROD ASSEMBLY

## NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.

1	95236-01	04	STOP
1	95234-01	03	STOP
1	95232-01	02	THREADED ROD
1	95212-01	01	THREADED ROD ASSEMBLY
QTY	PART NO.	ITEM	DESCRIPTION
			LIST OF MATERIALS

APPROVALS	DATE
DRAWN: JEFF CLARKE	18 OCT 2012
CHECKED: E. BURGAIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	

<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-9087 fax: (403) 250-8333 www.aerodesign.ca			
BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT THREADED ROD ASSEMBLY			
SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	95212	0

13004

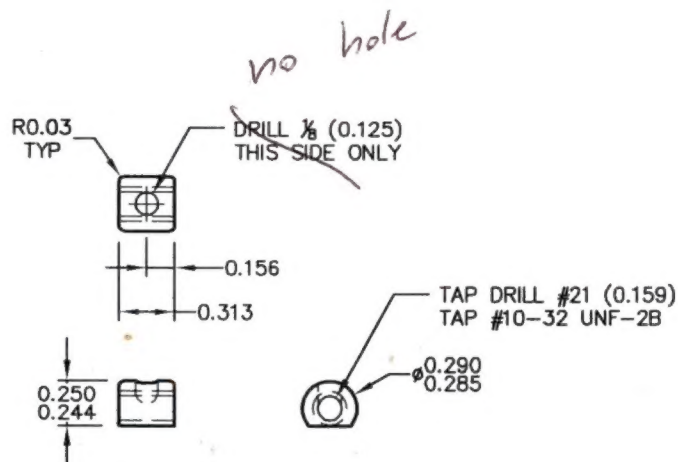
$\phi$  5/16 Stainless



WO # 2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



01 STOP

# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

		95234-01	01	STOP	304 STAINLESS STEEL	ASTM A479	Ø0.313 ROD				
01	PART NO.	ITEM	DESCRIPTION		MATERIAL	MATERIAL SPEC	STOCK SIZE				
QTY	LIST OF MATERIALS										
					APPROVALS		DATE		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 www.aerodesign.ca		
					DRAWN: JEFF CLARKE		18 OCT 2012				
					CHECKED: E. BURGON						
					UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2* X.XX ±0.03 X.X ±0.1				BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - STOP		
				SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.			
				SHEET 1 OF 1		A4	95234	0			



WO# 2014-50

Approved Manufacturing Facility 73-04

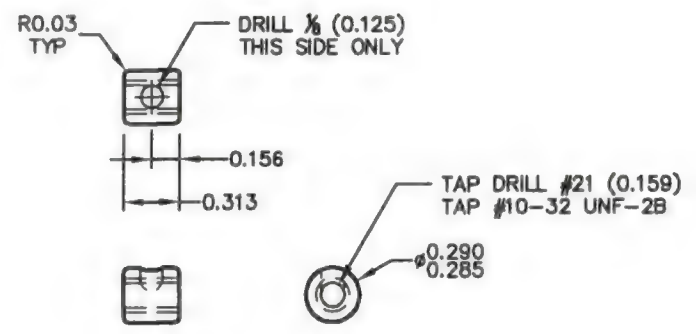
Form 20.F.06

Rev. Original 27 May 2013

2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



01 STOP

NOTES

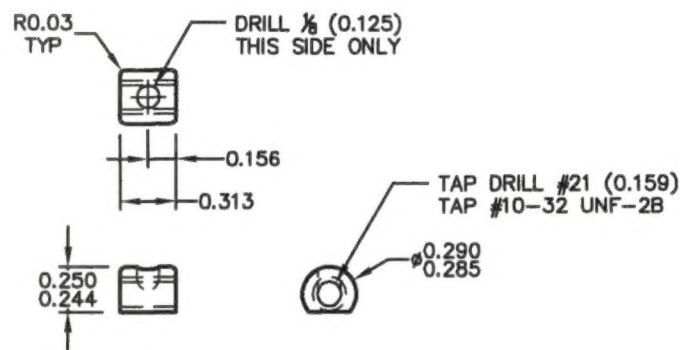
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

		95236-01		01	STOP	304 STAINLESS STEEL		ASTM A479	#0.313 ROD	
01	PART NO.		ITEM	DESCRIPTION		MATERIAL		MATERIAL SPEC		STOCK SIZE
QTY	LIST OF MATERIALS									
			APPROVALS		DATE		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8888 www.aerodesign.ca			
			DRAWN: JEFF CLARKE		18 OCT 2012					
			CHECKED: E. BURGAIN				<b>BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - STOP</b>			
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1							
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.						
SHEET 1 OF 1		A4	95236	0						

2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



01 STOP

# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

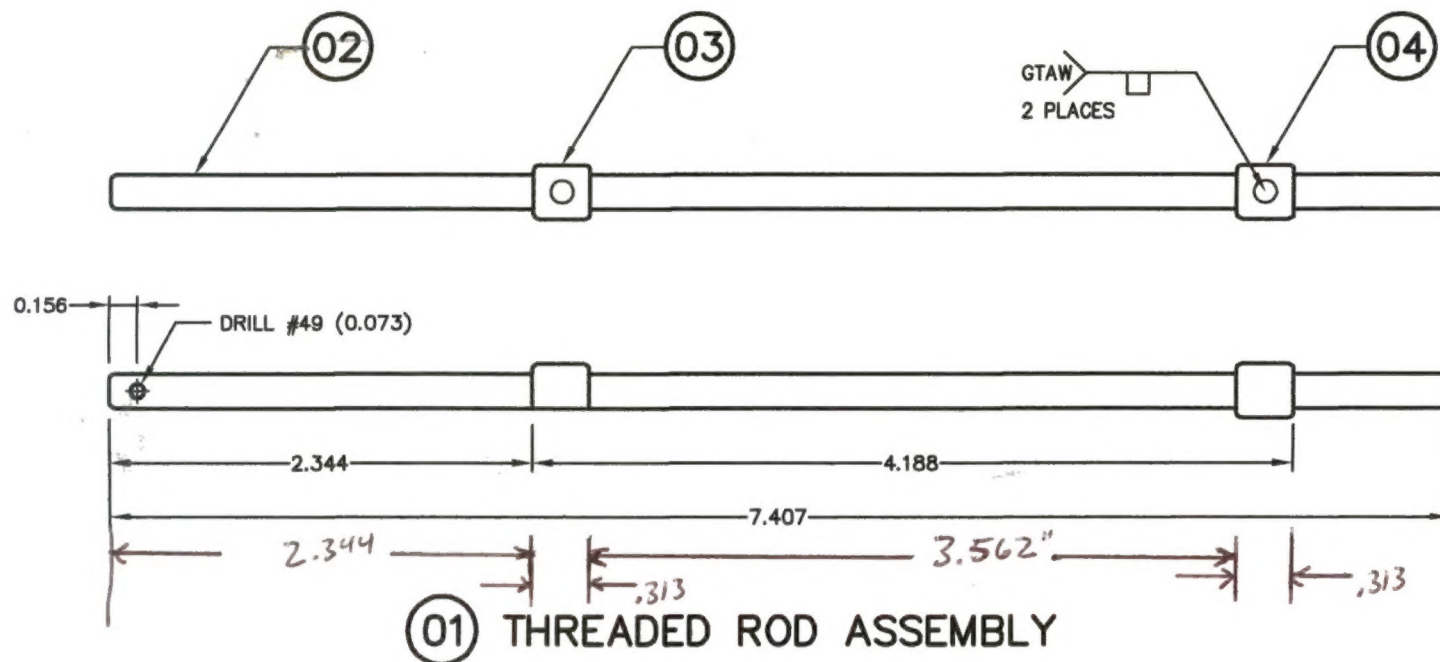
	95234-01	01	STOP	304 STAINLESS STEEL	ASTM A479	Ø0.313 ROD
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
				APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8335 www.aerodesign.ca
				DRAWN: JEFF CLARKE	18 OCT 2012	
				CHECKED: E. BURGAIN		
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		BELL 206B, 208L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - STOP
				SCALE 1 : 1	DWG. SIZE	DWG. NO.
				SHEET 1 OF 1	A4	95234
						0



2014-50

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 304 STAINLESS STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.

1	95236-01	04	STOP
1	95234-01	03	STOP
1	95232-01	02	THREADED ROD
	95212-01	01	THREADED ROD ASSEMBLY
QTY	PART NO.	ITEM	DESCRIPTION
			LIST OF MATERIALS

APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 260-9087 fax: (403) 260-8888 www.aerodesign.ca		
DRAWN: JEFF CLARKE	18 OCT 2012			
CHECKED: E. BURGON				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS X.XXX ±0.010 ANGLES ±1/2° X.XX ±0.03 X.X ±0.1		<b>BELL 208B, 208L SERIES, 407          CYCLIC FRICTION REPLACEMENT          THREADED ROD ASSEMBLY</b>		
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1		A4	95212	0

2014-50

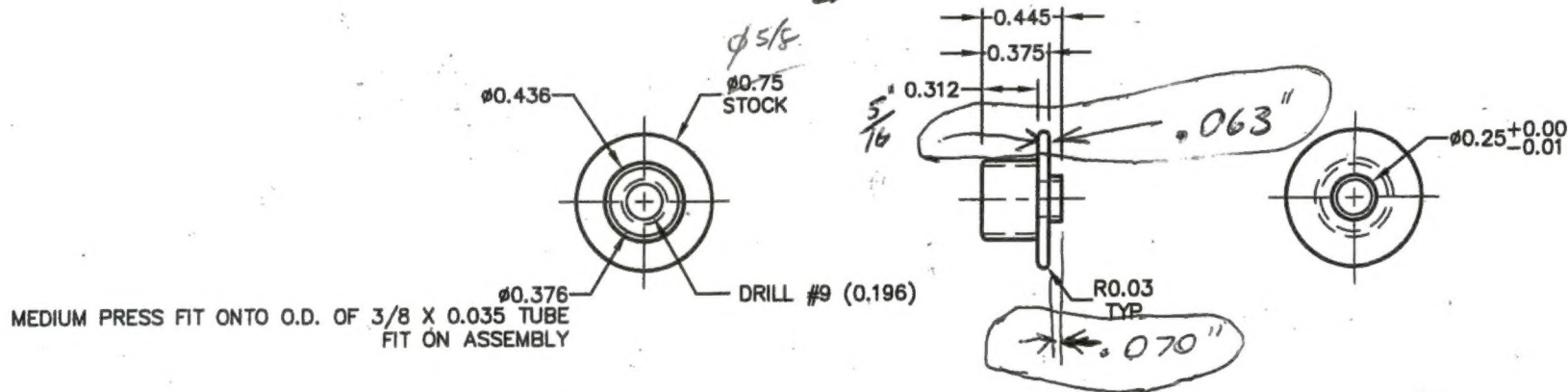
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*

# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

*change this dim.*



01 CAP

Material PO # 12044

		95224-01		01	CAP	304 STAINLESS STEEL		ASTM A479	#0.75 ROD		
01	PART NO.		ITEM	DESCRIPTION		MATERIAL		MATERIAL SPEC		STOCK SIZE	
QTY	LIST OF MATERIALS										
						APPROVALS		DATE		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 890M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8888 www.aerodesign.ca	
						DRAWN: JEFF CLARKE		18 OCT 2012			
						CHECKED: E. BURGAIN					
						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1					
						BELL 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - CAP					
						SCALE 1 : 1		DWG. SIZE	DWG. NO.		REV.
						SHEET 1 OF 1		A4	95224		0

- cut blanks @  $\frac{5}{8}$ " long
- face
- Turn O.D. to collar
- ~~center~~ champher corners
- center drill
- drill thru with #9 drill
- drill with "U" drill to  $\frac{5}{16}$ " depth
- slot drill to  $\frac{5}{16}$ "
- deburr bore

→ Turn material around

- face to length
- Face to face of collar while turning to dia.
- champher edges
- scotch brite O.D. of collar
- deburr I.D. of hole